

Date: Wednesday, 3/21/2007 1:59:00 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARSHOE
Job Number	31398		
Estimate Number	12788		
P.O. Number	N/A	Part Number	D356413
This Issue	3/21/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3564 REV A
First Issue	N/A	Project Number	N/A
Previous Run	31347	Drawing Revision	A
Written By		Material	N/A
Checked & Approved By	<u>SAH 07.03.21</u>	Due Date	3/30/2007
Comment	Est Rev A New Issue 07-03-08 ec	Qty:	10
Urn:	Each		

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 .063 Sheet	
Comment: Qty.: 0.1785 sf(s)/Unit Total : 1.7850 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>M101873</u> <u>SAH</u> <u>07/03/24</u> <u>⑩</u>			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> <u>SAH</u> <u>07/03/25</u> <u>⑩</u> <u>SAH</u> <u>07/03/24</u> <u>⑩</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SAH</u> <u>07/03/24</u> <u>⑩</u>			
4.0	QC8	SECOND CHECK	
Comment: SECOND CHECK <u>SA</u> <u>07.03.24</u> <u>⑩</u>			
5.0	BRAKE NC	NC BRAKE	
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT and DT <u>m.F.</u> <u>07 - 03 - 30</u> <u>⑩</u>			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 1:59:00 PM
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Drawing Name: WEARSHOE

Job Number: 31398

Part Number: D356413

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Jc70402



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

7.0 POWDER COATING

POWDER COATING



m101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Sd

07/04/03

(13)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



PD/04/03



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



PD/04/03



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/05

Job Completion



u St. M. d

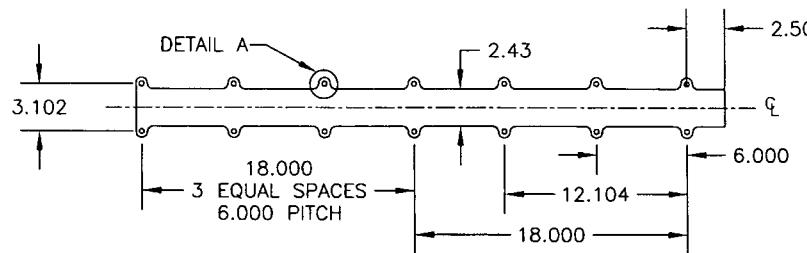
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

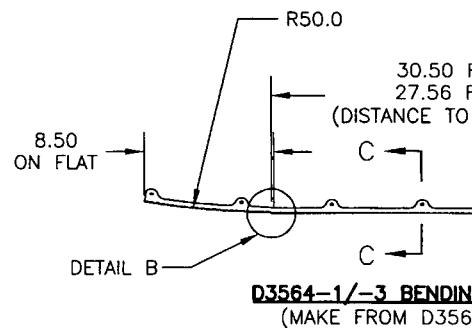
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

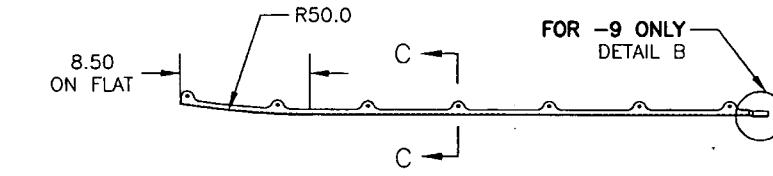


D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)

FOR -1 ONLY
DETAIL B



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

FOR -9 ONLY
DETAIL B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *31398*

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

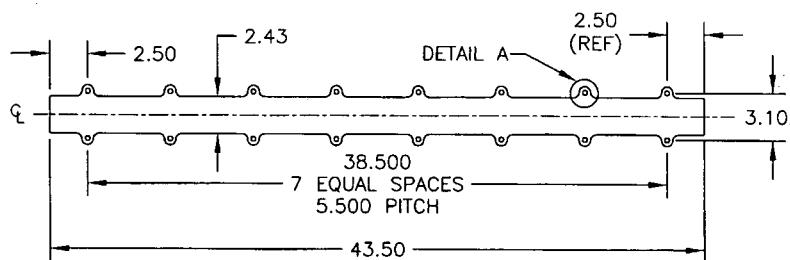
- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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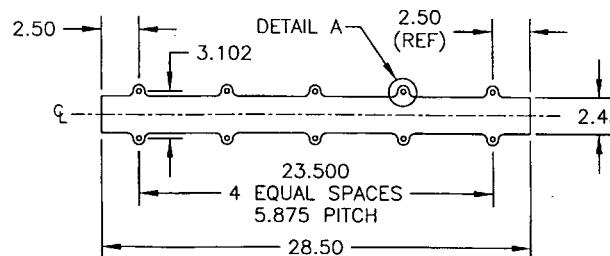
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A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART
<i>P4</i>	<i>P4</i>	DART
CHECKED	APPROVED	DRAWING NO.
<i>MM</i>	<i>MM</i>	D3564
DATE		REV. A
06.12.18		SHEET 1 OF 2
TITLE		SCALE
WEARSHOE		1:8

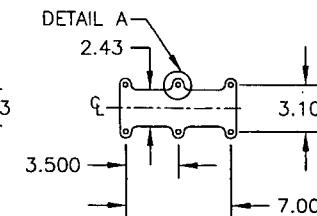
RELEASED
57-07-28 #



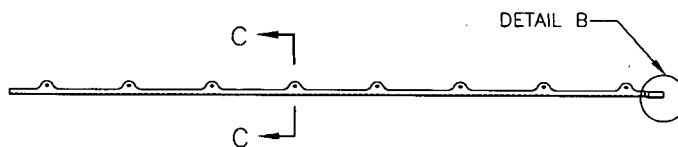
D3564-5F FLAT PATTERN



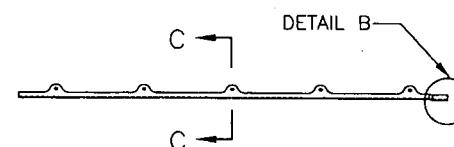
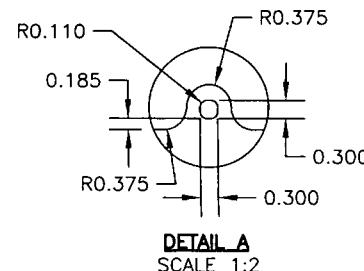
D3564-7F FLAT PATTERN



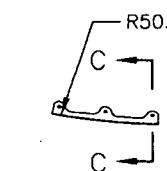
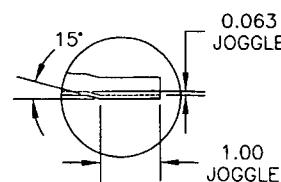
D3564-13F FLAT PATTERN



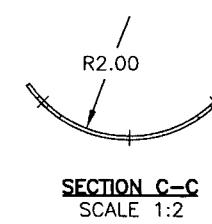
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



RELEASER
07/02/78

NO. 21398
WORK ORDER
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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
PH	PH		REV. A
CHECKED	APPROVED		SHEET 2 OF 2
DATE	TITLE		SCALE
06.12.18	WEARSHOE		1:8

DART AEROSPACE LTD

Work Order: 31398

Description:

Part Number: D356413

Inspection Dwg:

Rev:

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.43	+/- 0.010	2.428	/		Vern	
B 3.500	+/- 0.030	3.495	/		Vern	
C 7.000	+/- 0.010	7.004	/		Vern	
D 3.102	+/- 0.010	3.102	/		Vern	
E 0.300	+/- 0.010	0.306	/		Vern	
F 0.300	+/- 0.010	0.302	/		Vern	
G R0.375	+/- 0.010	R0.375	/		R-G	
H R0.110	+/- 0.010	R0.110	/		R-G	
I 0.063	+/- 0.010	0.059	/		Vern	
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	SAD
Date:	07/03/24

Audited by:	SJ
Date:	07/03/24

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

